



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A94-2706-00-01

Job Sheet 170600



Part No: RBE350A94-2706-00-01

Job Qty: 24 ea

3053913

Part Name: Pin



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Due Date: 2/27/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A94-2706-00 REV 6 IPP REV A 18-01-16 NEW ISSUE JFC VERIFIED DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	24 Ea		2/26/18	0.00	0.00	Start Up Small Fab-2		MLL
110	Small Fab	24 pcs		2/27/18	0.00	12.00	Small Fab-3		MLL DAS 38
120	QC	24 pcs		2/27/18	0.00	0.00	QC5		
121	Outsource	24 pcs		2/27/18	0.00	0.00	Outsource12	0039417	CT 18-03-03 3.41161h
123	Packaging	24 pcs		2/27/18	0.00	0.00	Packaging2		AT (DAS) 11 MAR 28 2018
125	QC	24 pcs		2/27/18	0.00	0.00	QC6		9-89
127	Small Fab	24 pcs		2/27/18	0.00	6.00	Small Fab-8		9-89
129	QC	24 pcs		2/27/18	0.00	0.00	QC5		MAR 28 2018
130	Packaging	24 pcs		2/27/18	0.00	0.00	Packaging3-1		
140	QC21-SA	24 Ea		2/27/18	0.00	0.00	QC21		DAS 21 9-89 MAR 28 2018

Part Op 90 - see engineering sign off for lanyard

Descriptions: 110 - Assemble as per DWG, Sheet 2 - Loctite 600 B 138828 Exp: 10/19
121 - Issue P/O to Groupe Altech; PO 039417 - Black oxide finish, MIL-C-13924C Class 1 - Certificate of Conformity is required
123 - Receive
127 - Fabricate lanyard 2.75 inch and Assemble as per DWG

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31 5016493	Ferule 1/16 X 3/8" - Aluminum	48 Ea (2 ea)	90-Start up Operation	
91595A142	Dowel Pin Ø3mm x 40mm	24 Ea (1 ea)	90-Start up Operation	
CL-2-C	Lanyard Wire	9.9840 ft (.416 ea)	90-Start up Operation	
NAS 1756-12	Remove Before Flight	24 (1 ea)	90-Start up Operation	
RBE350A94-2706-00-01A	Pin Shaft	24 Ea (1 ea)	90-Start up Operation	

Part Specifications

Specifications could not be found.

Plex 1/17/18 11:33 AM Dart.lajeunesse.marie

DML 3-23



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S053913



Part: RBE350A94-2706-00-01

Job No: 170600

Serial No/Batch: S053913

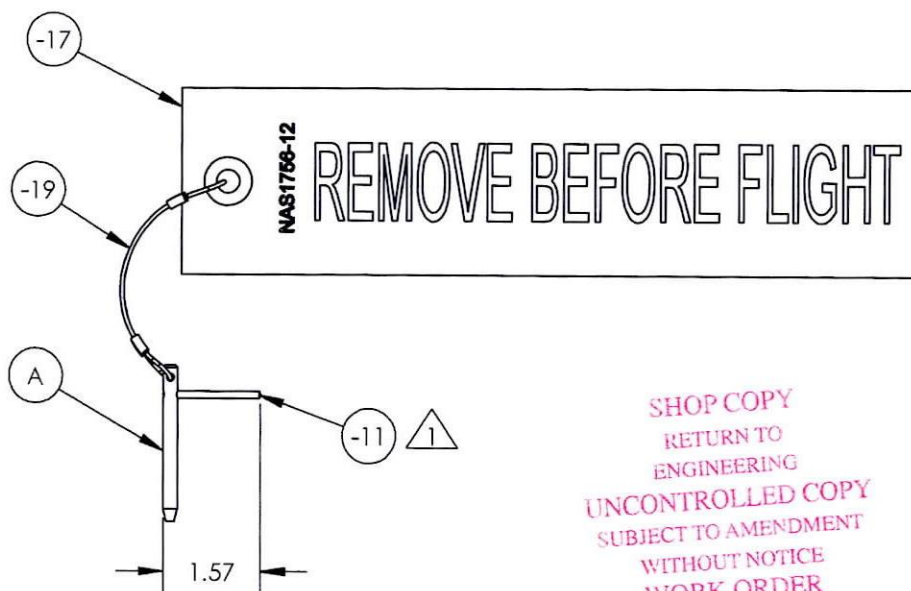
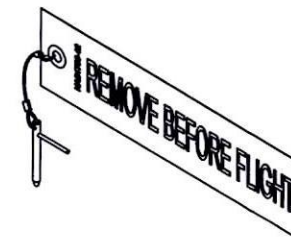
Revision: 6

Inspector:

Date: 03/22/18

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
6	16-0281	-01, -03, -05, -07, -09 ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D. ADDED -17, -19, NOTE 1		1/12/2017	RJC	JAG



SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 1761600 MWS
18-01-18

ASSY P/N	A P/N
-01	-01A
-03	-03A
-05	-05A
-07	-07A
-09	-09A

NOTE:

1 USE LOCTITE 680 TO ASSEMBLE.

DART AEROSPACE	
TITLE RIGGING PIN SET	
DWG NO. RBE350A94-2706-00-01	REV 6
MAT'L REPT TREAT FINISH BLACK OXIDE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/✓
SPEC QMSI-6.2.2, B.O. REV D	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: PERRITT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	EUROCOPTER AS350/355
APPROVED: GILBERT	
SCALE 1:3	DATE 9/11/2009
SHEET 2 OF 3	

-01, -03, -05, -07, -09

PIN

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039417**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039417

PO Date: 3/23/18

Due Date: 4/3/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	171481	RBE703A94-1130-01-25	Tab Adjuster Handle -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 Water Seal - Certificate of Conformity is required	Firmed	4/3/18	6 pcs	0 pcs	6 pcs	\$6.00/pcs	\$36.00
2	171483	RBE703A94-1130-01-29	Tab Adjuster Clamp : URF 17-623 -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 - Certificate of Conformity is required	Firmed	4/3/18	6 pcs	0 pcs	6 pcs	\$6.00/pcs	\$36.00
3	171604	RBW6405G06131-3G-1	Reaction Weldment -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	4/3/18	2 pcs	0 pcs	2 pcs	\$6.00/pcs	\$12.00
4	170608	RBE350A94-2706-00-09	Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/3/18	6 pcs	0 pcs	6 pcs	\$1.55844156/pcs	\$9.35

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	170604	RBE350A94-2706-00-05	Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/3/18	6 pcs	0 pcs	6 pcs	\$1.55844156/pcs	\$9.35
6	170606	RBE350A94-2706-00-07	Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/3/18	6 pcs	0 pcs	6 pcs	\$1.55844156/pcs	\$9.35
7	170602	RBE350A94-2706-00-03	Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/3/18	12 pcs	0 pcs	12 pcs	\$1.55844156/pcs	\$18.70
8	170600	RBE350A94-2706-00-01	Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/3/18	24 pcs	0 pcs	24 pcs	\$1.55844156/pcs	\$37.40
9	171469	RBE703A94-1130-01-11	Angle Indicator -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEALANT - Certificate of Conformity is required	Firmed	4/3/18	6 pcs	0 pcs	6 pcs	\$6.00/pcs	\$36.00
10	171485	RBE703A94-1130-01-33	Adjuster -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1: MIL-C-16173 Grade 4 -Certificate of Conformity is required	Firmed	4/3/18	14 pcs	0 pcs	14 pcs	\$1.55844156/pcs	\$21.82
11	174804	RBE350A94-3700-C-03	Bolt -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/3/18	3 pcs	0 pcs	3 pcs	\$1.55844156/pcs	\$4.68
12	171734	RBT18520-7	Pivot Bar Weldment -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/3/18	6 pcs	0 pcs	6 pcs	\$1.55844156/pcs	\$9.35

DAS
11
9-89

x24

18/03/27

3x

18/03/27



Certificat de Conformité / Certificate of Compliance

(007845-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

007845 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
27-Mar-2018		Aman		039417				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
4	RBE350A94-2706-00-09 Rev.	RBE350A94-2706-00-09 01 - OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	6	6	0	0	0
5	RBE350A94-2706-00-05 Rev.	RBE350A94-2706-00-05 01 - OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	6	6	0	0	0
6	RBE350A94-2706-00-07 Rev.	RBE350A94-2706-00-07 01 - OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	6	6	0	0	0
7	RBE350A94-2706-00-03 Rev.	RBE350A94-2706-00-03 01 - OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	BLACK-OXIDE CH	12	12	0	0	0
8	RBE350A94-2706-00-01 Rev.	RBE350A94-2706-00-01 01 - OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	24	24	0	0	0
10	RBE703A94-1130-01-33 Rev.	RBE703A94-1130-01-33 BLACK OXIDE COATING: MIL-C-13924 CLASS 1 : MIL-C-16173, GRADE 4	BLACK-OXIDE CH	14	14	0	0	0
11	RBE350A94-3700-C-03 Rev.	RBE350A94-3700-C-03 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	3	3	0	0	0
12	RBT18520-7 Rev.	RBT18520-7 01 - OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	6	6	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.